

FNH USA TACTICAL BOX MAGAZINE INSTALLATION AND OPERATING INSTRUCTIONS FOR FN SPR DBM EQUIPPED RIFLES

Thank you for purchasing the FNH USA Tactical Box Magazine (TBM) Kit for your FN SPR DBM 308 Winchester bolt-action rifle. If your FN SPR rifle does not currently have the factory installed Detachable Box Magazine (DBM), the TBM Kit will not fit your rifle. These instructions are included to augment the Owner's Manual that is included with your rifle. If you no longer have that manual, please contact the FNH USA Customer Service Center for a complimentary replacement. Please read these instructions carefully before attempting install the TBM Kit or loading the TBM magazines into you FN SPR rifle. These instructions cover the differences in the use of the TBM versus the factory Detachable Box Magazine (DBM) as described in your Owner's Manual. Please follow all other warnings and cautions included in your FN SPR Owner's Manual.

⚠WARNING

BEFORE ATTEMPTING TO INSTALL THE TBM KIT AND MAGAZINE ASSEMBLY INTO YOUR FN SPR RIFLE, ENSURE THAT YOUR RIFLE IS COMPLETELY UNLOADED AND DOES NOT CONTAIN ANY AMMUNITION. REMOVE THE MAGAZINE AND BOLT FROM THE RIFLE BEFORE BEGINNING ANY WORK ON THE RIFLE. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. FAILURE TO FOLLOW THESE WARNINGS MAY RESULT IN SERIOUS INJURY OR DEATH.

⚠CAUTION

THE FOLLOWING INSTRUCTIONS FOR THE TBM KIT INSTALLATION REQUIRE DISASSEMBLY OF YOUR RIFLE BEYOND WHAT IS REQUIRED FOR NORMAL MAINTENANCE. IF YOU ARE NOT CONFIDENT THAT YOU HAVE BOTH THE SKILLS AND PROPER TOOLS TO COMPLETE THESE INSTRUCTIONS WITHOUT DAMAGING YOUR RIFLE OR HARMING YOURSELF OR OTHERS, PLEASE CONTACT THE FNH USA CUSTOMER SERVICE CENTER OR A REPUTABLE GUNSMITH FOR ASSISTANCE. READ AND UNDERSTAND THESE INSTRUCTIONS COMPLETELY BEFORE ATTEMPTING TO DO ANY WORK ON YOUR RIFLE.

TBM KIT CONTENTS

- 1- Tactical Box Magazine Bottom Metal / Trigger Guard Assembly, Short Action (#62639-01)
- 1- TBM 5-round Magazine, 308 Winchester (#62635-01)
- 1- TBM 10-round Magazine, 308 Winchester (#62635-02)
- 1- Front Action Screw (#62910-01)
- 1- Rear Action Screw (#62911-01)

TOOLS REQUIRED FOR INSTALLATION

Padded vice mounted on a solid work bench

Torque wrench capable of 65 inch pounds of torque, equipped with a 1/32" hex bit

Small wooden block

INSTALLATION PROCEDURE

- 1. Completely unload the rifle and verify it does not contain any ammunition.
- 2. Remove the magazine, open and remove the bolt to ensure the chamber is clear.
- 3. While it is not necessary to remove the scope from the rifle, you may remove it to protect it from possible damage while working on the rifle.
- 4. Place the rifle barrel in a well-padded vice, clamping the barrel just forward of the fore-end with the trigger guard / floor plate facing up. Do not clamp the rifle by the stock. Support the receiver of the rifle with a block on the scope rail if the scope is removed. Support the receiver on the rear scope ring if not (Figure 1).
- 5. Using a 1/32" hex wrench, loosen and remove both of the action screws located at the front and the rear of the trigger guard / floor plate assembly. (Figures 2 and 3).
- 6. Remove the rifle's existing DBM floor plate / trigger guard assembly by lifting it straight up and out of the stock (Figure 4).

FIGURE 1



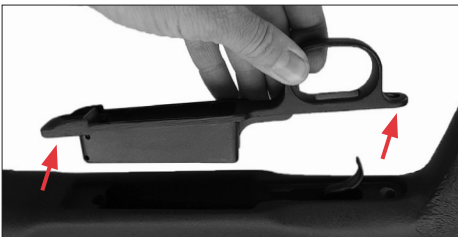
FIGURE 2



FIGURE 3



FIGURE 4



- 7. Insert an empty TBM magazine into the TBM trigger guard assembly and ensure it latches properly. This will help align the trigger guard assembly to the receiver when mounted in the stock. Place the TBM floor plate / trigger guard assembly straight down into the stock recess from which the DBM was just removed (Figure 5).
- 8. Place the two new action screws into the proper holes located at the front and rear of the new TBM floor plate / trigger guard assembly. The shorter screw goes in the front hole. Start both of the screws into the receiver before tightening either one with the torque wrench.
- 9. Starting with the front action screw, begin tightening each screw until it is slightly snug. Alternating between the screws, tighten each of the screws a quarter turn at a time using a torque wrench set at 65 inch pounds until both screws are at the correct torque setting and the wrench clicks (Figure 6).
- 10. Remove the magazine by pressing one of the release buttons located on either side of the new bottom metal assembly. Apply the torque of 65 inch pounds to each of the screws a second time starting with the front screw.

FIGURE 5



FIGURE 6



⚠WARNING

BEFORE ATTEMPTING TO FUNCTION TEST THE TBM MAGAZINE ASSEMBLY INSTALLED IN YOUR FN SPR RIFLE, ENSURE THAT YOUR RIFLE IS COMPLETELY UNLOADED AND DOES NOT CONTAIN ANY AMMUNITION. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. FAILURE TO FOLLOW THESE WARNINGS MAY RESULT IN SERIOUS INJURY OR DEATH.

FUNCTION CHECK PROCEDURE

- 1. Remove the rifle from the vice. After double checking to verify that there is no ammunition in the rifle or the magazine(s), perform a function check:
 - a. Insert the bolt and close it on an empty chamber.
 - b. Place the "safety" in the rear or middle position (SAFE) and attempt to pull the trigger. The striker should not fall.
 - c. Place the "safety" in the forward (FIRE) position and attempt to pull the trigger. The striker should drop normally to the fired position.
 - d. Open the bolt to cock the striker and close the bolt. Place the "safety" in the middle (SAFE) position. Open the bolt and pull it to the rear.
 - e. Insert an empty TBM magazine into the magazine well, pressing it up into the well and allow it to click and lock into position. Attempt to remove the magazine by pulling downward without pushing the magazine release. It should not release.
 - f. Close the bolt on an empty chamber. There should be no drag or interference felt between the bolt and the magazine.
 - g. Press either magazine release button to remove the magazine.

⚠CAUTION

IF THE RIFLE FAILS AT ANY STEP OF THE FUNCTION CHECK, CONTACT THE FNH USA CUSTOMER SERVICE CENTER OR A QUALIFIED GUNSMITH IMMEDIATELY FOR FURTHER ASSISTANCE.

NOTE: THE TACTICAL BOX MAGAZINE KIT MAY ALSO FIT FN PBR, PBR-XP AND TSR-XP RIFLES EQUIPPED WITH THE FACTORY DBM ASSEMBLY. SOME MINOR FITTING OR INLETING OF THE STOCK MAY BE REQUIRED DEPENDING ON THE INDIVIDUAL RIFLE. PLEASE CONSULT A QUALIFIED GUNSMITH OR CONTACT THE FNH USA CUSTOMER SERVICE CENTER.

⚠WARNING

DO NOT LOAD A LIVE CARTRIDGE INTO THE CHAMBER OF YOUR FN SPR RIFLE EXCEPT AT A LOCATION THAT IS SAFE AND SUITABLE FOR LIVE FIRING. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AT ALL TIMES. FAILURE TO FOLLOW THESE WARNINGS MAY RESULT IN SERIOUS INJURY OR DEATH.

LOADING THE TACTICAL BOX MAGAZINE

Loading the Tactical Box Magazine (TBM)

1. With the “safety” in the intermediate position, lift the bolt handle and pull the bolt to the rear. Verify the rifle and magazine(s) are completely unloaded and do not contain any ammunition.
2. Remove the Tactical Box Magazine from the rifle by pushing inward on the button located on either side of the rear of the magazine well (Figures 7 and 8). Let the magazine drop free into your hand. If the magazine does not drop free, continue to press on one of the magazine release buttons and gently pull the magazine free with the other hand.
3. With the bullet tips pointing toward the front of the magazine, place the base of the cartridge on the follower between the feed lips on the magazine body and the feed lips on the magazine follower. Press the cartridge down with your thumb until it can be pushed rearward under the feed lips. Push the cartridge fully to the rear of the magazine so there is maximum clearance between the bullet tip and the front of the magazine body (Figure 9). It may be helpful to push the rear of the follower down slightly with the thumb of your other hand to facilitate sliding the cartridge back under the magazine feed lips.

NOTE: DO NOT ATTEMPT TO FORCE THE CARTRIDGE BASE DOWN BETWEEN THE WAVED-SHAPED STEPS AT THE FRONT OF THE FEED LIPS ON THE MAGAZINE BODY, AS THIS CAN CAUSE DAMAGE TO THE MAGAZINE. THE BASE OF EACH CARTRIDGE MUST BE FLUSH WITH THE REAR OF THE MAGAZINE. IF THE NOSE OF A CARTRIDGE PROTRUDES BEYOND THE FRONT OF THE MAGAZINE, IT COULD CAUSE FEEDING PROBLEMS OR INTERFERE WHEN INSERTING THE MAGAZINE INTO THE RIFLE.

4. Repeat the process by pressing the base of another cartridge down on the previously loaded cartridge just forward of the magazine feed lips and sliding the cartridge under the lips and fully rearward. Use your other hand to push down slightly on the rear of the cartridge already in the magazine. Do this until the magazine is fully loaded. Do not attempt to fill the magazine beyond its five or ten round capacity as this may cause feeding malfunctions or damage the magazine. Magazine capacities are indicated by ports in the rear of the magazine body. These ports are labeled with the numeral 5 or 10. Stop filling the magazine when a cartridge case is visible through one of the ports marked 5 on the five-round magazine or one of the ports marked 10 on the ten-round magazine (Figure 10).
5. When you are at a suitable location where it is safe to load your rifle, consult your owner’s manual regarding the correct procedure for loading a live cartridge from the magazine into the chamber.

UNLOADING THE TACTICAL BOX MAGAZINE

1. Place the “safety” in the intermediate position.
2. Keeping the muzzle pointed in a safe direction, open the bolt and remove the cartridge in the chamber. Leave the bolt open.
3. Depress the magazine release button on either side of the magazine well and remove the magazine from the rifle.
4. Recheck the chamber to ensure it is empty and contains no cartridge. If it does, cycle the action (as explained earlier) to eject the loaded cartridge while keeping the muzzle pointed in a safe direction.
5. Ensure the “safety” is in the intermediate or on safe position.
6. Unload the magazine by sliding the cartridges forward and out of the magazine one at a time until the magazine is empty.

FIGURE 7



FIGURE 8



FIGURE 9

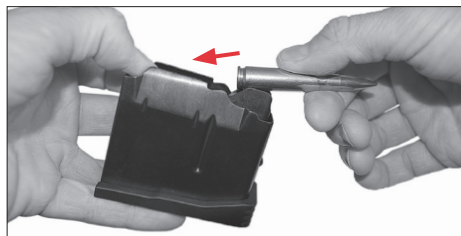


FIGURE 10



DISASSEMBLY OF THE TACTICAL BOX MAGAZINE

⚠ WARNING

MAGAZINE PARTS ARE UNDER SPRING TENSION. SOLVENTS AND LUBRICANTS ARE EYE IRRITANTS. USE PROPER EYE PROTECTION WHENEVER ASSEMBLING, DISASSEMBLING OR CLEANING THE TACTICAL BOX MAGAZINE. FAILURE TO FOLLOW THESE WARNINGS MAY RESULT IN SERIOUS EYE INJURY.

1. If not already done, remove the magazine from the rifle and completely unload it as described above.
2. Using a tool such as a small screwdriver, gently press on the protruding part of the magazine retainer through the hole in the magazine bottom plate (Figure 11). Hold the retainer in that position and then gently slide the bottom plate slightly forward (Figure 12).
3. While holding the magazine bottom retainer (which is subjected to the force of the magazine spring) with the screwdriver. While ensuring the magazine bottom plate is pointed away from your face and body, carefully slide the plate off the magazine body and then carefully release the pressure of the magazine.
4. While ensuring the magazine bottom is pointed away from your face and body, remove the magazine spring together with the follower and retainer from the magazine body.

FIGURE 11

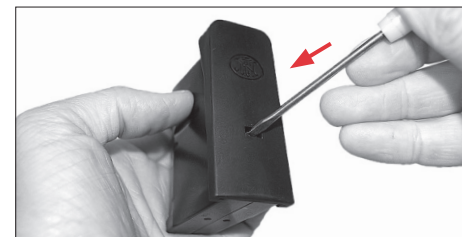


FIGURE 12



FIGURE 13



This level of disassembly is sufficient to perform thorough cleaning (Figure 13). Further disassembly should be only carried out by a qualified gunsmith, an authorized armorer or by the FNH USA Product Service Center.

CLEANING AND LUBRICATION OF THE TACTICAL BOX MAGAZINE

1. Disassemble the magazine as described above.
2. Use a soft cloth or rag to clean all parts of the magazine.
3. Using a soft cloth lightly moistened with lubricant, lightly apply lubricant to all external surfaces of the metal parts. Wipe off excess lubricant. Ensure that the inside of the magazine is dry.
4. Reassemble the magazine as described below.

REASSEMBLING THE TACTICAL BOX MAGAZINE

1. With the components of the magazine clean, ensure that the magazine follower and the magazine bottom catch fit correctly onto the follower spring and that the assembly is oriented correctly.
2. While ensuring the magazine bottom is pointed away from your face and body, insert the follower, spring and retainer into the magazine body, follower end first.
3. While holding the magazine spring in the magazine body and ensuring the magazine bottom is pointed away from your face and body, slide the magazine bottom plate onto the magazine body. The magazine bottom plate can only be slid back into position when the magazine bottom retainer is pushed far enough into the magazine body.
4. Ensure the magazine bottom retainer locks into position in the magazine bottom plate. A slight tap on the front of the magazine may be required to seat fully the retainer. The raised portion of the retainer will be visible in the hole in the magazine bottom plate when it is properly locked into place.

If you have any questions or comments concerning these instructions or if you need a new Owner’s Manual for your FN SPR rifle, please contact the FNH USA Customer Service Center at (800) 635-1321. For additional information about this and any other FNH USA product, please visit us at www.fnhusa.com. To request a FNH USA catalog please call (703) 288-3500.

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